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gegründet 1751

SAUER 202 Take Down



***Handling and
Safety Instructions***

S 202

Take Down

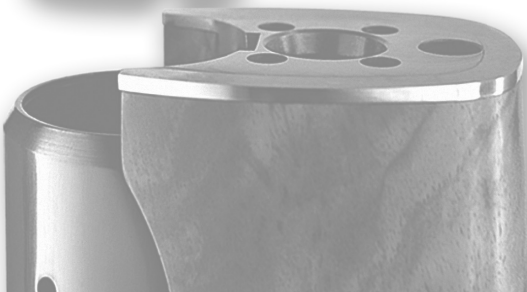


Non Plus Ultra



The Take Down rifle – synonymous with perfect gunmaking and dream of the ambitious hunter. Only the world's best gunsmiths have been able to custom-build it for a few professionals. By blending advanced technology with masterful workmanship, SAUER has succeeded in bringing the Take Down legend into serial production. The result is a complete rifle action that offers uncompromising and repetitive accuracy as well as maximum flexibility for any hunting, anywhere.

- Based on the SAUER 202 design, the receiver is the supporting element of the rifle. Immune from stock bedding issues, the action practically supports itself.
- The barrel and receiver are connected by a snug-fitting cone plug that is free of play and compensates for wear. The state-of-the-art manufacturing process ensures minimum tolerances and maximum precision.
- Six lugs lock the bolt directly in the barrel. This guarantees perfect headspace after every disassembly and assembly and prevents wear and tear at the plug connecting barrel and receiver.
- With the press of a button, six lugs lock the fore-end directly into the steel receiver.
- The S 202 Take Down can be disassembled without tools to a length of 70 cm and re-assembled within seconds for immediate action. There is no tool to forget or lose, no screw that is too tight or too loose – the rifle is reduced to pure perfection and that leads to successful hunting.
- After assembly, the point of impact remains 100% consistent. There is no need for testfiring.
- The unlimited flexibility of the S 202 Take Down allows for changing of barrels and calibres from 6.5 x 55 to .458 Lott with a wide range of barrel lengths and contours.
- Trigger, safety, sights, stock options and, of course, the absolutely slick bolt action have all been adopted from the proven SAUER 202.
- All models are available for left-handers with left-handed action and buttstock.



Taper fit of barrel to receiver with a precision of 3 microns. 100% guaranteed to return to zero

Steel magnum receiver suitable for all calibres from 6.5 x 55 to .458 Lott

The bolt helps to disassemble the rifle. Simply retract it and the taper fit of barrel and receiver will release

Trigger and inner mechanics same as S 202

Hand cut checkering

Different buttstocks available

Bolt locks directly into the barrel

Push button to release fore-end

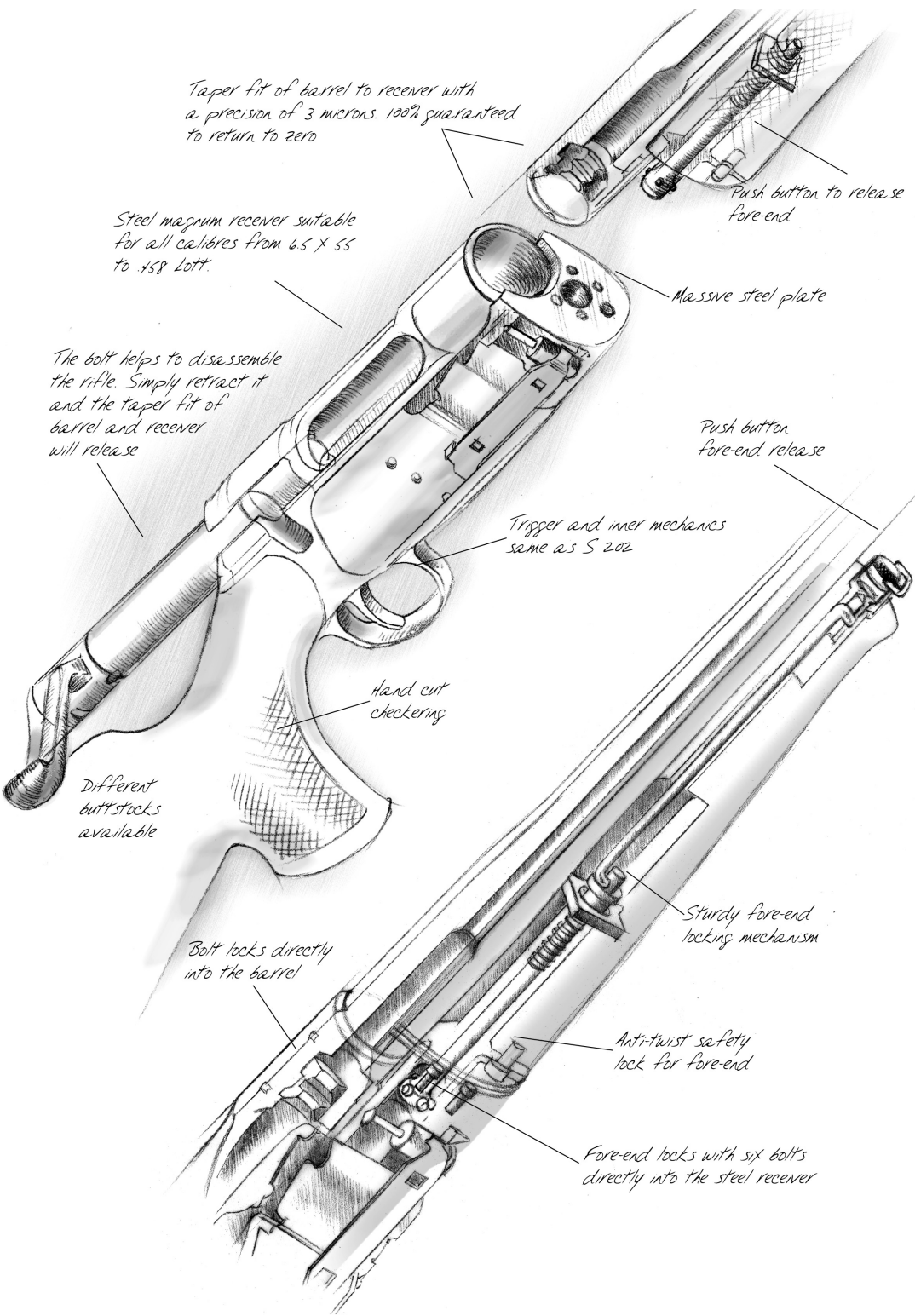
Massive steel plate

Push button fore-end release

Sturdy fore-end locking mechanism

Anti-twist safety lock for fore-end

Fore-end locks with six bolts directly into the steel receiver





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1 General instructions

Be sure to read through these instructions carefully before any manipulation on this SAUER gun.

Understanding these instructions and the technically correct implementation of the information contained therein are **imperative** for the correct preparation and safety during handling, maintenance and care of this SAUER gun. Do not use the gun until you have fully understood all safety instructions and handling procedures. Should you require further information, do not hesitate to contact your dealer, importer or the manufacturer.

Please observe the local and national legislation governing the ownership, carrying and use of firearms.

Be aware that this gun, like all firearms, is dangerous. The gun accompanying these Handling and Safety Instructions has been sold under the express understanding that the manufacturer and the importer of the gun decline any responsibility for consequences of manipulations on the gun or use of the gun. This applies in particular to liability for bodily harm or damage to property resulting in part or in whole to:

- use with criminal intent or negligent use,
- improper or careless handling,
- defective, incorrect, hand-charged or recharged ammunition,
- inadequate care of the gun (e.g. corrosion, damage),
- disregard of malfunctions,
- resale in contradiction of regional legislation and regulations, other circumstances beyond our direct and immediate control
- other circumstances beyond our direct and immediate control.

These limitations apply regardless of whether liability is asserted on the basis of contract, negligence or strict liability (including any failure to warn).

The manufacturer and the importer are not liable for incidental or consequential damages such as loss of use of property, commercial loss or loss of earnings and profits.

2 Safety regulations

- Never use the gun under the influence of alcohol or drugs, during illness or other complaints; they may influence your judgement and reflexes.
- Always treat the gun as loaded and unlocked until you have made sure to the contrary by unloading it.
- During all manipulations, keep the muzzle of the gun pointed in a safe direction. Safe directions are defined as areas where there are no people, other living creatures or other people's property.
- Never point the gun at doors, window panes, walls, concrete, stones or other flat surfaces (including water). Shots can penetrate such surfaces or be deflected into unsafe directions by them.
- Never aim at yourself or other people.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Always handle your gun as if the safety mechanisms were not functional. The best safety device is the correct, well-exercised and secure handling of the gun.



- Never shoot a gun into which there has been ingress of water, sand, dirt or other foreign bodies.
- Never release the tension on the firing pin 106 merely by pulling the trigger.
- Never let a loaded gun out of your hands.
- Always unload the gun immediately after shooting, before putting it down, putting it in its case or handing it to another authorised person.
- Never hand the gun to any person who has not thoroughly familiarised himself or herself with the safety regulations and handling of the gun by reading the accompanying instructions.
- Never leave the gun lying around unattended. Unauthorised persons can cause damage or threaten or kill people with it, for which you might be liable.
- Never store the gun loaded, but remove the magazine and verify through unloading there is no round in the barrel chamber.

2.1 Safety instructions

In the individual sections of these instructions, the following safety indications alert you to various risks:



WARNING!

Information on risks which, if not scrupulously observed, can lead to severe bodily harm or death.



CAUTION!

Information on risks which, if not scrupulously observed, can lead to bodily harm or damage to the gun.

CAUTION!

Information on technical requirements which, if not scrupulously observed, can lead to damage to the gun.

- Each safety indication consists of:
 - a header with a signal word, icon and a corresponding colour shading
 - a specification of the type and source of the risk
 - a specification of potential consequences if the safety indications are not observed
 - specifications of measures and prohibitions designed to avoid risks



3 Product description

3.1 Main parts



Fig. 1

Item Description

- 100 Bolt
- 200 Magazine tube
- 300 Barrel
- 400 Main stock

Item Description

- 500 Two-part front stock
- 600 Magazine
- 700 Trigger



3.2 Main features

The SAUER 202 Take Down is a high precision hunting rifle built in accordance with the latest state of knowledge, which can be disassembled without tools into its components rear stock and magazine tube, front stock and barrel. It is an easy to handle repeater with rifle trigger which can be fitted with a rear set trigger.

The modular construction makes it easy to change individual components including the calibre.

Both mechanical and optical aims can be fitted.

There is a wide range of accessories available. The SAUER 202 Take Down is also available as a left-handed version.

3.3 Scope of delivery

The standard scope of delivery includes:

- 1 x gun
- 1 x magazine
- 1 x special socket spanner (2 parts)
- 1 x Allan key
- 1 x Handling and Safety Instructions manual
- 1 x 10 g SAUER Premium gun grease
- 1 x SAUER plastic case
- 1 x Warranty card



Fig. 2, Standard scope of delivery in plastic case



4 Transporting the gun

4.1 Transport in assembled state

Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload and lock the gun (see section 5.6, 6.2).
3. Remove the bolt (see section 5.7.2).
4. If necessary remove the sling attachment (see section 7.1) to prevent scratching the stock components.
5. Clean the gun (see section 11).

4.2 Transport in the compact case

Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload the gun (see section 5.6).
3. Remove the sights/accessories (see section 13).
4. Clean the gun (see section 11).
5. Remove the front stock (see section 7.3).
6. Remove the barrel (see section 7.4).
7. Remove the bolt (see section 5.7.2).



WARNING!

Uncontrolled discharge of shot

May lead to death or severe injuries

- For your own safety and for the safety of others, always transport the gun in the unloaded condition (see Section 5.6), and decocked.
- Never carry a cocked gun containing a round in the barrel chamber.
- Always carry the gun in such a manner that, should you fall or otherwise slip, you are able to control the direction of the muzzle.
- Transport the gun separate from the ammunition in a locked carrying case.
- The gun and ammunition must not be accessible to children and other inexperienced or unauthorized persons.
- Ensure that you comply with all regional and national laws relating to the transport of firearms.



5 Handling the gun

5.1 Preparing the gun

Note:

The gun is supplied with a protective and preserving oil and grease coating, and excessive protective oil and grease must be removed prior to first commissioning.

The SAUER 202 Take Down is supplied in a shock-proof durable plastic case.

For safety reasons the bolt and the magazine must not be inserted during:

- first commissioning and
- taking possession of the gun.



WARNING!

**Undefined condition of the gun
May lead to death or severe injuries**

- If the shooter takes possession of the gun in any other condition it must be treated as loaded and unlocked.

5.2 Ammunition



WARNING!

Incorrect ammunition

May lead to death or severe injuries and damage to the gun

- For your gun, use only commercial grade ammunition in the original packaging, which corresponds to the calibre of the gun.
- Never use recharged, "reconditioned", hand-charged or non-standard ammunition in your gun.
- Never use dirty, wet, corroded, bent, damaged or oiled ammunition.
- Never spray lubricants, preservatives or cleaning agents directly onto the rounds.
- Never leave the ammunition lying around unattended.

Procedure:

1. Unload the gun (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Check whether ammunition is still in the barrel chamber or in the magazine.
4. Clean the barrel (see section 11.2).
5. In addition during first commissioning:
 - Clean external metal surfaces (see section 11).
6. If supplied in compact case:
 - Mount the barrel (see section 8.1).
 - Fit the front stock (see section 8.4).



5.3 Loading the gun (ready to fire)

**WARNING!**

**Insufficient awareness of the dangers
May lead to death or severe injuries**

- Never load or unload the gun inside a vehicle, inside a building or any other confined space (except in a designated firing range).
- Before loading, always wipe off any excess grease and oil and check that there is no obstruction in the bore of the barrel.
- Always keep the muzzle of the gun pointed in a safe direction.
- Do not place the finger onto the trigger tongue, but outside the trigger guard.
- Do not load the gun by inserting the magazine until immediately before shooting.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Never let a loaded gun out of your hands.

Procedure:

1. Unlock the gun (see section 6.1).
2. Insert the bolt (see section 5.7.3).
3. Open the bolt and pull it back to the stop.
4. Fill the magazine (see section 5.8.3).
5. Insert the magazine (see section 5.8.2).
6. Push the bolt forward and lock.
7. Lock the gun (see section 6.2).

The gun is loaded and ready to fire.

5.4 Discharging a shot

**WARNING!**

**Insufficient awareness of the dangers
May lead to death or severe injuries**

- Ensure that the target and the environment allow shots to be fired without danger.
- When discharging shots, ensure that your hands or any other parts of the body are located in front of, over or adjacent to the barrel muzzle or the ejection port.
- Never allow other persons to stand beside you where they might be struck by ejected cartridge cases.
- Always wear ear protection and safety glasses when shooting. Alert bystanders to the importance of wearing ear protection.
- Immediately stop shooting and unload the gun if you suspect that a round has not been chambered properly, a case is jammed, a bullet is lodged in the bore or a discharge sounded or felt weak or abnormal.
- Never attempt to dislodge a blockage in the barrel by firing another round.



Procedure:

1. Aim the gun at a safe target.
2. Unlock the gun (see section 6.1).
3. If necessary, set the trigger (see section 5.9.2).
4. Place finger on trigger tongue and pull back the trigger tongue to discharge the shot. The trigger behaviour depends on the trigger fitted (see section 5.9).
5. Keep the gun aimed at the target and repeat and fire further shots as required.
6. If the magazine is empty, reload the gun (see section 5.5).
7. Lock and unload (see section 5.6).

**WARNING!**

Gun is ready to fire
May lead to death or severe injuries

- If you decide to end the shooting session, immediately unload the gun.

5.5 Reloading during shooting

**WARNING!**

Insufficient awareness of the dangers
May lead to death or severe injuries

- Never let the gun out of your hands.
- Keep the gun pointed at the safe target.

Procedure:

1. Lock the gun (see section 6.2).
 2. Remove the empty magazine (see section 5.8.1).
 3. Unlock the gun (see section 6.1).
 4. Open the bolt and pull it back to the stop.
 5. Fill the magazine (see section 5.8.3).
 6. Insert full magazine and check engagement (see section 5.8.2).
 7. Push the bolt forward and lock.
 8. Lock the gun (see section 6.2).
- The gun is loaded and ready to fire.



5.6 Unloading the gun



WARNING!

Gun is ready to fire

May lead to death or severe injuries

- Never let the gun out of your hands before it is unloaded.
- The gun is loaded, a round is located in the chamber of the barrel.
- Never place your hand over the ejection port of the bolt.

Procedure:

1. Lock the gun (see section 6.2).
2. Aim the gun at a stop-butt.
3. Remove the magazine (see section 5.8.1).
4. Unlock the gun (see section 6.1).
5. Open the bolt.
 - The cartridge or cartridge case is pulled out of the barrel chamber and ejected.
6. Check that the round has been ejected and there are no more rounds in the barrel chamber.
7. Empty magazine.
8. Pick up ejected round and clean the gun.



WARNING!

Gun has not been cleaned sufficiently

May lead to death or severe injuries and damage to the gun

- The gun must be cleaned after every shooting session (see section 11).

The gun is unloaded.

5.7 Bolt

5.7.1 Cocking the bolt

In order to insert the bolt **100** into the gun, the firing pin must be cocked.

A cocking indication provides information about the cocking state of the bolt.

Procedure:

1. Insert the tapered end of the supplied key into the side opening of the lock **113**.
2. Turn the lock towards the cocking wheel until it engages.

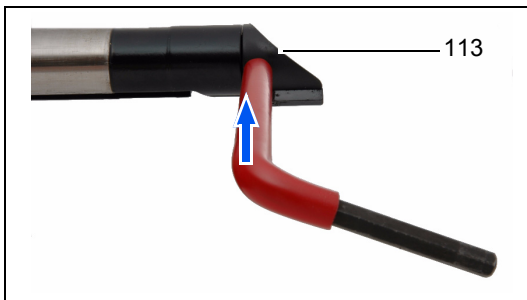


Fig. 3, Cocking the bolt



Fig. 4, Tension indication 103 of the bolt (left: cocked, right decocked)



5.7.2 Removing the bolt

Procedure:

1. Unlock the gun (see section 6.1).
2. Open the bolt and pull approximately half way back.
3. Fully push in the bolt lock bolt slide **711** and pull out the bolt.



Fig. 5

5.7.3 Inserting the bolt



WARNING!

**Uncontrolled discharge of shot
May lead to death or severe injuries**

- The gun must be unloaded.

1. Unlock the gun (see section 6.1).
2. Cock the bolt (see section 5.7.1).
3. Press the bolt lock bolt slide and insert the cocked bolt into the magazine tube, close and lock.

CAUTION!

Gun may be damaged

- Never use force when inserting the bolt.

4. As functional check: carry out a repeater action.
5. Check the safety functions with the gun unloaded:
 - The safety and unlocking bolts must be freely moveable.
 - Firing a shot must not be possible in the locked state.
 - The bolt must not open in the locked state.
 - With the trigger set the gun must automatically unset when the bolt is opened.
6. If problems arise during the functional check or with the safety function, remove the bolt and repeat steps 1 to 5.



5.7.4 Uncock the firing pin

	WARNING!
Uncontrolled discharge of shot May lead to death or severe injuries Only uncock the firing pin with the gun unloaded and the barrel chamber empty.	

Procedure:

1. Unload the gun and check that there is no round in the barrel chamber (see section 5.6).
2. Pull the trigger tongue and slowly close the bolt with the trigger tongue held pulled.

Note:

- The cocking indication must not be visible (see Fig. 4).

5.8 Magazine

5.8.1 Removing the magazine

Procedure:

1. Hold magazine **600** by hand.
2. If fitted: Push magazine safety towards the magazine (see section 10.2).

CAUTION!
Magazine may fall out Magazine may be damaged When removing the magazine always keep your hand exactly underneath the magazine.

3. Press the stud **207** with the index finger of the same hand.
4. Remove magazine.
5. Empty magazine.



Fig. 6



5.8.2 Inserting the magazine

Procedure:

1. Insert the magazine into the magazine shaft and push upwards until the magazine engages audibly. Do not jam the magazine.
2. If fitted: Push magazine safety towards the barrel (see section 10.2).

5.8.3 Loading the magazine

Procedure:

1. Push the rear feeder down.
2. Push the round from the front under the magazine lip.

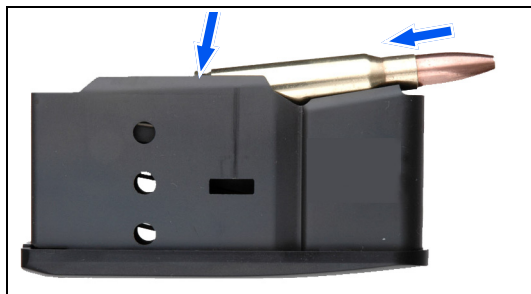


Fig. 7

5.9 Trigger

Three trigger variants are available for the SAUER 202 TakeDown: A rifle trigger, a rifle trigger with rear set trigger, and a pressure point match trigger.

CAUTION!

Gun may be damaged

- The trigger can be changed, but this must only be carried out by a gunsmith.

5.9.1 Rifle trigger

Note:

- The trigger weight has been set to approx. 15 N (1.500 g) at factory.

The rifle trigger is a direct trigger without creep.

- The shot is fired after the resistance has been overcome.



WARNING!

Uncontrolled discharge of shot May lead to death or severe injuries

- For safety reasons the rifle trigger weight must only be modified by a qualified gunsmith.
- The minimum setting for the trigger weight is 10 N (1.000 g).



5.9.2 Rifle trigger with rear set trigger

Note:

- The trigger weight of the rifle trigger has been set to approx. 13 N (1.300 g) at factory.

The rifle trigger with rear set trigger is a direct trigger without creep, which allows for a reduced trigger resistance by way of setting. The trigger resistance of the rear set trigger can be set individually (see page 15).

- The shot is fired after the resistance has been overcome.

Priming



WARNING!

Uncontrolled discharge of shot May lead to death or severe injuries

- For safety reasons the rifle trigger weight must only be modified by a qualified gunsmith.
- The minimum setting for the trigger weight is 10 N (1.000 g).
- The set trigger can be triggered already by the slightest vibration. Therefore the trigger must not be set until immediately before firing the shot. Aim the gun at a stop-butt. If the intended shot cannot be fired, immediately lock and reset the gun.

Procedure:

1. Unlock the gun (see section 6.1).
2. Press the trigger tongue **706** forward with the thumb until it engages.

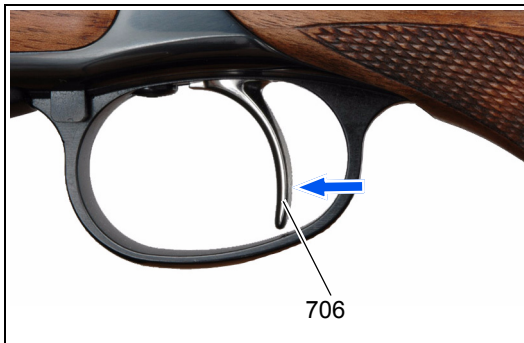


Fig. 8



Resetting

Procedure:

1. Lock the gun (see section 6.2).
2. Aim the gun at a stop-butt.
3. Grip the trigger tongue with the thumb and index finger and pull back slowly.

Note:

- If the bolt is opened, a reset will be carried out automatically.

Modifying the trigger weight

Note:

- The trigger weight of the set trigger has been set to approx. 3 N (300 g) at factory. It can be modified using the adjustment screw **729**.

Adjusting downwards:

- Turn the adjustment screw **729** clockwise.

Adjusting upwards:

- Turn the adjustment screw **729** anti-clockwise.

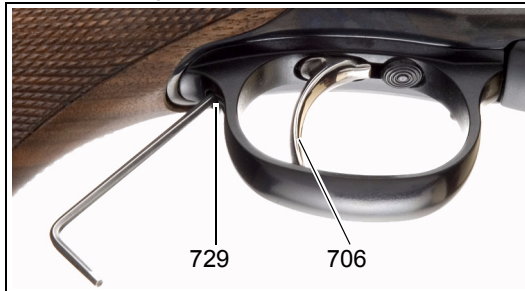


Fig. 9



WARNING!

Uncontrolled discharge of shot

May lead to death or severe injuries

- The trigger weight must not be adjusted to a value below 3 N (300 g).
- Set the set trigger for rough hunting use clearly harder than for use in the shooting range, because the trigger finger often loses feeling during the cold season.
- If the gun unsets automatically when locked, the trigger weight has been set too low. It must immediately be set to a value where the gun does not automatically unset when locked.



5.9.3 Match trigger

Note:

- The trigger weight has been set to approx. 7 N (700 g) at factory.

The match trigger is a pressure point trigger with adjustable creep.

- The trigger tongue must be pulled until it reaches a noticeable resistance (pressure point).
- The shot is fired after the resistance has been overcome.



WARNING!

Gun is ready to fire

May lead to death or severe injuries

- For safety reasons the trigger weight must only be modified by a qualified gunsmith. He can adjust the trigger weight between approx. 5 N (500 g) and 10 N (1.000 g).

Creep adjustment (see Fig. 9):

Note:

- The creep travel cannot be adjusted to "zero", there will always be a travel by design.

Short creep:

- Turn the adjustment screw **729** clockwise.

Longer creep:

- Turn the adjustment screw **729** anti-clockwise.



WARNING!

Gun is ready to fire

May lead to death or severe injuries

- Any screws sealed with red varnish must not be interfered with by the user. If these screws are manipulated, the warranty will be void.
- The screw for reducing the creep must only be turned clockwise to a degree that the safety lock will still work properly.
- If the free movement of the safety lock is impeded, the screw **must** be **immediately** turned back **anti-clockwise** until the normal safety lock function is restored.

5.10 Sights

Dependent on the model selected the SAUER 202 Take Down is supplied with various sights or without open sights. If a gun is supplied with open sights, those have been - dependent on the sight type - calibrated to 50 or 100 metres. The sights can be changed at a later date, but this should only be carried out by a gunsmith.



6 Safety lock

The safety lock of the SAUER 202 Take Down is an indirect firing pin safety lock.

It locks the trigger tongue, the trigger stop, and the firing pin nut and thus blocks all safety-relevant components.

Its function is based on a principle proven a million times over: A single function – a single button.

- The safety lock bolt is positioned at the top of the handle of the stock.
- The unlock bolt is positioned well protected and easy to grip within the trigger guard in front of the trigger tongue.

6.1 Unlocking

Procedure:

1. Slide the unlock bolt **714** with the trigger finger upwards to the stop.
 - The safety lock bolt **210** is also pushed upwards thereby and releases a red signal ring.

Note:

Gun unlocked:

- Red signal ring visible
- The safety lock bolt can be felt with the thumb



Fig. 10, Gun unlocked:



6.2 Locking

CAUTION!

Gun may be damaged

- If the gun has its trigger set and is then locked, the gun cannot be unlocked and opened. To unlock and open the gun again, it has to be unset manually (see section 5.9.2).

Procedure:

1. Press the safety lock bolt **210** down with thumb up to the stop.
 - The unlocking bolt **714** is pushed out of the trigger device at the bottom where it can be easily controlled with the trigger finger.

Note:

Gun locked:

- Red signal ring not visible
- The unlocking bolt can be felt with the trigger finger



Fig. 11, Gun locked



7 Dismantling



WARNING!

Gun is ready to fire

May lead to death or severe injuries

- There must be no magazine in the gun.
- Before stripping your gun, ensure once again that it is unloaded (see section 5.6).

7.1 Removing the sling attachment

Procedure:

1. Firmly press in the spring bolt.
2. Turn the sling attachment gently and pull out.



Fig. 12, rear sling attachment bushing

Note:

- Clean and oil the sling attachment regularly.

7.2 Remove magazine

see section 5.8.1

7.3 Front stock removal

Procedure:

1. Press and hold down the button at the tip of the front stock.
2. Pull off the front stock in a straight line forward movement.



Fig. 13

7.4 Barrel removal

Procedure:

1. Hold the gun in the left hand (for right handers) with the thumb and index finger put around the barrel just above the magazine tube (see Fig. 14). The rifle is pointing with the muzzle upwards. The main stock must not rest on the stock cap.



Fig. 14



Fig. 15

2. Using the remaining fingers grip the magazine tube firmly and press the hand together with the thumb and index finger exerting a pulling force on the barrel (see Fig. 14 and Fig. 15).
3. Open the slide with the right hand and let it drop down vertically without stopping it (see Fig. 15 and Fig. 16).

Note:

- This momentum releases the firm conical plug-in attachment of barrel and magazine tube which can usually be felt in the fingers of the left hand, since the barrel already moves a short distance out of the magazine tube.



Fig. 16

4. Pull barrel out in a straight line movement to the front (see Fig. 17).



Fig. 17

Note:

- If it can still not be pulled out, the procedure with dropping the bolt might have to be repeated once or twice until the momentum releases the firm conical plug-in attachment of barrel and magazine tube. Once more, make sure that the thumb and index finger of the left hand exert a noticeable pull on the barrel.
- If a rifle has several barrels, it is possible that one barrel sits more tightly in the magazine tube than another. This does not affect the precision or functionality of the rifle.

7.5 Removing the bolt

see section 5.7.2

7.6 Remove main stock (optional)

Procedure:

1. Unscrew the main stock screw in the hole of the main stock **401** anti-clockwise using the long end of the special spanner supplied (approx. 5 turns).
2. Remove the main stock by pulling downwards.

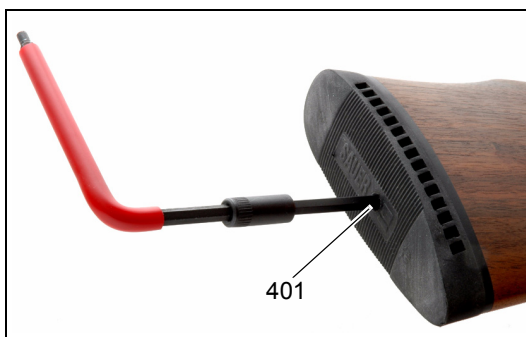


Fig. 18



8 Assembly

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- There must be no magazine in the gun.

CAUTION!

Gun may be damaged

- Only assemble cleaned gun parts.

8.1 Fitting the main stock

Corresponding figure, see Fig. 18.

Procedure:

1. Slide the main stock onto the gun.
2. Hand-tighten the main stock screw clockwise with the long end of the special spanner supplied (approx. 5 turns).

8.2 Fitting the barrel

CAUTION!

Gun may be damaged

- Do not use force when inserting the barrel into the magazine tube.
- Prior to fitting ensure that the internal surfaces of the magazine tube and the external surfaces of the barrel near the plug-in attachment are free of foreign matter, completely clean and absolutely dry.

Procedure:

1. Insert the barrel into the magazine tube such that the block (S) at the bottom of the barrel next to the groove (N) rests on the metal plate of the magazine tube. Then press the barrel against the metal plate and simultaneously turn the groove until the barrel audibly rests on the base of the magazine tube.



Fig. 19



8.3 Inserting the bolt

see section 5.7.3

8.4 Fitting the front stock

Corresponding figure, see Fig. 13.

Procedure:

1. Attach the front stock in a straight line to the system connection whilst holding the unlocking button at the tip of the front stock pressed down.
2. Release button.
3. Insert and lock bolt (see section 5.7.3).
4. Fit the sling attachment (see section 8.6).

Note:

- The minute radial play of the barrel and front stock in the assembled condition are due to the technical design and guarantee the easy disassembly of the rifle. This does not negatively affect the precision and stability.

5. Check:

With the front stock fitted **no** gap must be visible between the two metal plates (see Fig. 20).

If a gap is visible (see Fig. 21), the barrel is not far enough in the magazine tube preventing the front stock from locking fully.

In this case the barrel must be removed and reinserted correctly following the instructions above.



Fig. 21

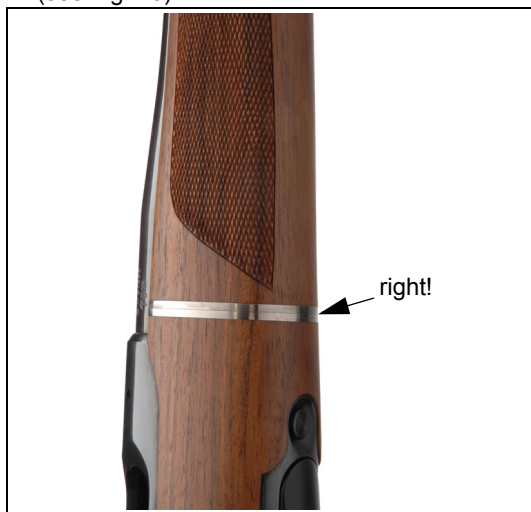


Fig. 20



8.5 Inserting the magazine

CAUTION!

Gun may be damaged

- An incompletely locked front stock can come loose when shooting. It can also damage the magazine tube.

see section 5.8.2.

8.6 Fitting the sling attachment

Corresponding figure, see Fig. 12.

Procedure:

1. Insert the bolt of the rear sling attachment into the sling attachment bushing **407**.
2. Press in the spring bolt.
3. Gently turn the sling attachment until the bolt safety lock engages.
4. Insert the bolt of the front sling attachment into the front sling attachment bushing **48**.

Note:

- The sling attachment must be aligned exactly 90° to the orientation of the barrel.
- The bolts must protrude clearly above the edge of the sling attachment body.



9 Modular principle

Components manufactured to perfect dimensions make it possible to produce a hunting rifle optimally tailored to your needs. It also allows you to modify and specialise your S 202 Take Down at a later date.

The complete and current option selection and individual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de).

9.1 Calibre change retrofit table

The S 202 Take Down allows you to use all available barrels and calibres in a single gun.

All information about the calibres and barrel contours available and the required front stocks can be found in the price lists, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de).

Note:

- After changing the calibre the gun must be recalibrated if a single sight is used for several barrels. If a separate sight is available for each barrel and has been calibrated accordingly, then only the sight needs to be changed at the time of a calibre change. Recalibrating will not be necessary.

9.1.1 Medium calibre

Barrel with calibre	Magazine	Bolt
.25-06 Rem.	Magnum for Medium	Magnum for Medium
6.5x55	Magnum for Medium	Magnum for Medium
.270 Win.	Magnum for Medium	Magnum for Medium
7x64	Magnum for Medium	Magnum for Medium
.30-06	Magnum for Medium	Magnum for Medium
8x57IS	Magnum for Medium	Magnum for Medium
9.3x62	Magnum for 9,3x62	Magnum for Medium

9.1.2 Magnum and BigGame calibres

Barrel with calibre	Magazine	Bolt
6.5-284 Norma	Magnum	Magnum for Medium
6.5x68	Magnum	Magnum
.270 Wby. Mag.	Magnum	Magnum
7 mm Rem. Mag.	Magnum	Magnum
.300 Win. Mag.	Magnum	Magnum
.300 Wby. Mag.	Magnum	Magnum
8x68S	Magnum	Magnum
.375 H&H	.375 H&H	Magnum
.416 Rem. Mag.	.416 Rem. Mag.	Magnum
.458 Lott	.458 Lott	Magnum



10 Extras

10.1 Muzzle brakes

If your SAUER 202 Take Down is equipped with a muzzle brake (MagNaPort, Pendelton or SAUER muzzle brake) the sound pressure during firing increases by approx. 30 percent. This can result in severe damage to the hearing including deafness. For this reason a suitable ear protection must be worn whenever the gun is used.

	WARNING!
Increased sound pressure Potential severe hearing damage	
• When firing the gun with a muzzle brake always wear a suitable ear protection.	

10.1.1 SAUER muzzle brake

The SAUER muzzle brake is screwed onto the barrel if required. For this the gun must be prepared at factory with a corresponding thread and a rear offset sight. If the brake is not in use the barrel thread is protected by a metal screw cap included in the scope of delivery.

The gun is supplied ex factory with the protective cap attached and has been calibrated in this configuration. To remove the protective cap unscrew it anti-clockwise from the barrel. To attach the muzzle brake, place the supplied brake onto the barrel thread and hand-tighten clockwise.



Fig. 22

Note:

- With every change from protective cap to muzzle brake or vice versa the gun must be recalibrated, because the aiming point position will change considerably dependent on the chosen thread attachment!



10.2 Magazine lock MagLock

The special magazine lock MagLock is a 100% effective safety lock against unintentional unlocking of the magazine. Nonetheless, the shooter can rapidly change the magazine when required.

To lock (a) the magazine unlock button slide the cap on the button forward. To unlock (b) slide the cap back.

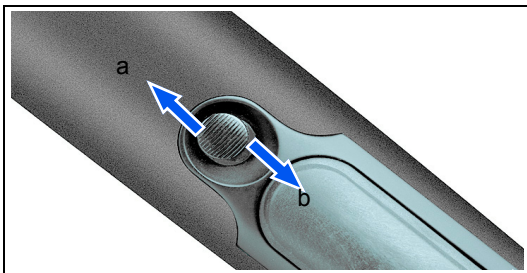


Fig. 23, a) locking, b) unlocking

10.3 Express sights

The SAUER Express sights are the perfect aiming device for hunting moving game or for all those who frequently hunt without telescopic sights. The sights consist of an Express sight with a mechanical sight and a flap. The Holland & Holland front sight consists of a large white bead sight and a small brass bead sight which is visible when the large front sights are folded.

Guns with these sights are always calibrated as follows:

- Fixed sight with large white bead sight to 50 metres (letting the aim rest),
- Folding sight with small brass bead sight to 100 metres (letting the aim rest).



Fig. 24



11 Care

11.1 General

Proper functioning and precision of the gun can only be maintained through regular and expert care. The gun must be cleaned and protected against corrosion after each use. The bore must be cleaned and protected against corrosion after each firing. Wooden stocks must be treated with a suitable agent in accordance the corresponding instructions and must be protected against the weather.

For the optimum care for your SAUER 202 Take Down

we recommend SAUER care products, e.g. the SAUER Premium gun grease.

For a normal cleaning it is sufficient to remove/ dismantle the following gun parts:

- Magazine
- Bolt
- Rifle sling

If the gun has been exposed to extreme moisture or is heavily soiled, it is recommended to remove or dismantl the following gun components:

- Rifle sling
- Telescopic sights
- Magazine
- Front stock
- Barrel



WARNING!

Gun is ready to fire

May lead to death or severe injuries

- There must be no magazine in the gun.
- Before stripping your gun for cleaning, ensure once again that it is unloaded (see Section 5.6).

11.2 Cleaning the barrel

CAUTION!

Gun may be damaged

- Never clean barrel from the front end and do not use a steel or brass wire brush as it can destroy the smooth surface of the barrel. Use a suitable cleaning rod and a brush of matching calibre.
- Detergents can damage the surface of the gun. Read the manufacturer's indications and warnings before using solvents or cleansers.

Procedure:

1. Unload the gun (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Instead of the bolt insert a cleaning aid ("False lock") for the exact centred guidance of the cleaning rod.
4. Clean the bore and barrel chamber from the back using suitable fluids or grease (observe the respective instructions for use) and a suitable, calibre matched, bronze or plastic cleaning brush.
5. Check whether deposits of the rounds have collected in the sections. If necessary, clean the barrel with a commercial grade barrel cleaning agent (observe the respective instructions for use) designed for firing residue.



6. Coat the barrel bore and the barrel chamber with a little gun oil or gun grease.
7. Dry the barrel bore and the barrel chamber from the back using a plastic coated cleaning rod of the correct calibre.

11.3 External metal and wood surfaces

For the care and preservation of the external metal and wood surfaces we recommend SAUER Premium gun grease. Minute spherical Teflon® particles seal the pores of all wood and metal surfaces and provide perfect protection and optimal sliding characteristics.

Benefits:

- dry surfaces - dust etc. does not adhere;
- water and salt water proof;
- absolute corrosion protection;
- perfect sliding characteristics, reduced wear;
- resistant to sweaty palms;
- pressure resistant up to 57.000 kg/cm²;
- temperature resistant from -50 to +230 °C;
- perfect protection and care for steel **and** wood;
- neutral smell;

CAUTION!

Gun may be damaged

- Caring for the external metal surfaces is particularly important in wet weather or if the metal surfaces have come into contact with sweaty body parts.
- Always wipe dry the gun prior to preservation.

Procedure:

1. Thoroughly clean the gun using suitable cloths and cleaning agents.
2. Thinly apply the grease with a cloth or sponge over the whole gun (including the stock) including all mechanical and moveable parts.
3. After a reaction time of at least 60 minutes wipe dry and polish the gun with a clean cloth.
4. Dependent on the weather and frequency of use the protective effect will last between two to six months.

**Note:**

- The sling attachments must also be cleaned regularly and their locking mechanism oiled.
- So-called "water stains" on the stock after rain cannot be avoided. Dependent on the dust and dirt particle content of the rain this phenomenon is stronger or weaker. It is not a defect in the stock finish.
- No oil or grease film is required for the plug-in attachment between the barrel and magazine to function properly. However, this area must be protected well against corrosion in order to ensure easy dismantling even after longer periods of rest for the rifle. As corrosion protection for the inside radius of the magazine tube and the rear part of the barrel inserted into it non-resin oils or grease with a high level of corrosion protection are suitable (e.g. SAUER Premium gun grease). After oiling or greasing and following the reaction time specified by the manufacturer the substance must be removed again by polishing to prevent impeding the proper action of the plug-in attachment.

12 Dealing with problems**12.1 Cause and correction of malfunctions**

Gun maintenance (cleaning and inspection) according to the instructions can prevent malfunctions.

Should, nevertheless, a malfunction occur during shooting, proceed as follows:

**WARNING!****Uncontrolled discharge of shot****May lead to death or severe injuries**

- Hold the gun pointed in the firing direction (safe direction) and keep your finger off the trigger while you carry out the steps described below.

Procedure:

1. Remove magazine and unload the gun (see section 5.8.1).
2. Open the bolt.
 - The cartridge or cartridge case is pulled out of the barrel chamber and ejected.
3. Check that no bullet, round, cartridge case or foreign matter is in the barrel chamber or barrel. If a projectile is lodged in the bore, strip the gun (see Section 7) and have the blockage removed with a suitable tool by a qualified gunsmith.
4. Remove all rounds, cases or foreign bodies. Clean, lubricate and assemble the gun (see Section 11 and 8).
5. Have the gun inspected by an armoured or gunsmith.



Fault	Potential cause	Remedy
No round chambered.	Magazine not properly inserted, deformed or dirty.	Insert magazine all the way until it engages (see section 5.8.2).
	Gun faulty.	Repair by manufacturer.
Bolt cannot be inserted into the magazine tube.	Bolt lock bolt slide not pressed.	Push in the bolt lock bolt slide (see section 5.7.3).
	Mainspring is uncocked.	Cock the belt (see section 5.7.1).
	Gun faulty.	Repair by manufacturer.
Gun trigger cannot be set.	Gun is uncocked.	Cock the gun (see section 5.7.1).
	Gun faulty.	Repair by manufacturer.
Gun cannot be locked.	Gun is uncocked.	Cock the gun (see section 5.7.1).
	Gun faulty.	Repair by manufacturer.
Gun can be neither unlocked nor opened.	Gun has trigger set and is locked.	Uncock the gun (see section 5.9.2).
	Gun faulty.	Repair by manufacturer.
Gun trigger is set. When pulling the trigger no shot fires, instead the trigger returns to the start position.	Trigger was pulled to the side.	Reset, pull trigger back straight/linear.
Gun disengages automatically when locking.	Set trigger is set too soft.	Set gun harder immediately (see section 5.9.1).
Front stock comes loose when shooting.	Barrel was not fully in the magazine tube preventing the stock from engaging fully.	Remove and refit barrel (see section 8.2).
Barrel cannot be removed from magazine tube.	Cone sits too tight.	Repeat step "dropping the magazine tube".
Front stock difficult to move.	Dry out metal surface at the stock end.	Grease or oil stock end.



12.2 Shipping the gun

Note:

- Familiarise yourself fully with regional legislation governing the shipping and transportation of firearms.
1. Check the gun to ensure that it is unloaded and decocked.
 2. Pack the gun well (if possible in its original packaging) to prevent damage in transit. To prevent the gun being recognised as such during shipping, wrap the original packaging in a second outer layer. Do not include any accessories in the shipment.
 3. Enclose a letter stating the following:
 - your full name
 - your full address (state street, not P.O. Box)
 - your daytime telephone number
 - model and serial numbers of the gun
 - detailed description of the problem encountered or the service work to be performed.
 4. Send the gun properly insured and carriage-paid (packages without correct postage will not be accepted) to:
 - the sales outlet from which you purchased the gun
 - the local Sauer & Sohn dealer,
 - the Sauer & Sohn agent (importer) for your country
 - if there is no local appointed Sauer & Sohn dealer or Sauer & Sohn agent in your country, to J.P. Sauer & Sohn GmbH.

13 Installation of optics and accessories

Note:

- When fitting the telescopic sights please ensure an exact fit between the mounting base and the system housing. If a maladjustment is compensated for by firmly tightening the assembly screws there is a risk that the system sleeve will be damaged or the installation comes loose when a load is applied.



CAUTION!

Improper installation of telescopic sights Gun may be damaged

- A damage of the system sleeve results in a change of the sleeve shape which can make changing the barrel difficult or impossible on the one hand, and can have a negative impact on the firing precision on the other. The threads for the assembly screw could also be damaged or destroyed.
- For rifles assembled differently than described here, the J.P. & Sohn GmbH will not accept any warranty of the functionality and accurate firing.
- Please only install mounting bases onto the system sleeve whose radii match those of the sleeve exactly.
- It should also be ensured that the mounting base is not only screwed on but also glued widely and evenly using a **dual component adhesive**.

J. P. & Sohn GmbH recommends the original SAUER swivel mounting.



14 Technical specifications

Functional principle	Take Down Repeater rifle	
Action type	Direct lug locking in the barrel	
Calibre	Medium: .25-06 Rem.; 6,5x55; .270 Win.; 7x64; .30-06; 8x57 IS; 9,3x62 Magnum: 6,5-284 Norma; 6,5x68; .270 Wby. Mag.; 8x68 S; 7mm Rem. Mag.; .300 Win. Mag.; .300 Wby. Mag. BigGame: .375 H&H Mag.; .416 Rem. Mag.; .458 Lott	
Length, overall	Medium: approx. 1.120 mm (with barrel length 600 mm) Magnum: approx. 1.170 mm (with barrel length 650 mm) BigGame: approx. 1.120 mm (with barrel length 600 mm)	
Barrel length	Medium: 510, 560, 600 mm Magnum: 600, 650 mm BigGame: 600 mm	
Stock length (Monte Carlo stock)	approx. 355 mm	
Stock indentation (Monte Carlo stock); from top edge of magazine tube	front: 32 mm centre: 25 mm back: 50 mm	
Stock offset	5 mm	
Trigger weights	Pure rifle trigger: approx. 15 N Rifle trigger (with set trigger): approx. 13 N Set trigger: approx. 3 N Match trigger: approx. 7 N	
Magazine content	Medium: 3 rounds Magnum: 2 rounds BigGame: 2 rounds	
Replacement magazine	Medium: 4 rounds Magnum: 4 rounds BigGame: 4 rounds	
Weight without telescopic sights with steel magazine tube, 600 mm barrel length and Monte Carlo stock.	Medium: 3,8 kg Magnum: 3,9 kg BigGame: 4,1 kg	

Subject to change without notice



15 Accessories

Your SAUER 202 Take Down is a modular hunting gun which can be easily adapted to new uses at a later date. The complete and current option selection and individual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de). There you will also find all telescopic sight assemblies, replacement barrels, replacement magazines, sights and any other gun accessories.

In addition Sauer & Sohn offers the following accessories for the perfect transport and stylish presentation of your gun and for successful hunting: More precise information can be found in the catalogue or on the internet at (www.sigsauer.de).



Abb. 25

16 Spare parts

J. P. Sauer & Sohn GmbH only supplies to authorised dealers in Germany or to the respective SAUER importer abroad. For ordering spare parts please always contact your dealer who will then forward your order accordingly to the importer (abroad) or Sauer & Sohn (Germany). To enable the speedy and focused processing of your order please always provide the following information when ordering spare parts:

- Model, caliber, barrel length, extras
- Gun number
- Item number from the spare parts list
- Designation of the desired spare part



Item Designation

100 Bolt assembly

- 102 Straight pin
- 103 Striking pin nut
- 104 Brazed nipple
- 105 Firing pin spring
- 106 Firing pin
- 107 Ejector pin
- 108 Ejector pressure spring
- 109 Clamping sleeve
- 110 Extractor
- 111 Pin for extractor spring
- 112 Bolt
- 113 Lock

200 Magazine tube assembly

- 201 Magazine ejector spring
- 202 Magazine case, light alloy or steel
- 204 Magazine catch
- 205 Guide pin
- 206 Pressure spring for magazine catch
- 207 Pressure bolt
- 208 Insert
- 209 2 Spring pins
- 210 Safety bolt
- 211 Threaded bolt
- 212 Set screw

300 Barrel assembly

- 301 Barrel
- 302 Spring collet
- 303 Pan head screw
- 304 Fixed sight
- 305 Pan head screw
- 306 Sight base
- 307 Pan head screw
- 308 Front sight base

Item Designation

400 Main stock assembly

- 401 Main stock
- 402 Retention sleeve
- 403 Main stock screw
- 404 Crown gear
- 405 Washer
- 406 Flat head wood screw
- 407 Sling attachment bushing
- 408 Butt
- 409 2 screws for butt

500 Front stock assembly

- 502a Front stock front part
- 502b Front stock rear part
- 503 Sling attachment bushing
- 504 Guide bush
- 505 Bar
- 506 Control bolt
- 507 Bush
- 508 Square nut
- 509 Support for front stock
- 510 Plate for front stock
- 511 Centering bush
- 512 Adapter for TakeDown barrel

513 Pan head screw

- 514 Bearing for front stock

515 Pressure spring

- 516 Locking bolt
- 517 Set screw

600 Magazine assembly

- 601 Magazine floor plate
- 602 Magazine spring
- 603 Feeder
- 604 Magazine case

Item Designation

700 Set trigger device

- 701 Set trigger hammer
- 702 Straight pin
- 703 Pressure spring
- 704 Trigger stop
- 705 Straight pin
- 706 Trigger tongue
- 707 Straight pin
- 708 Pressure spring
- 709 2 spacers
- 710 Rocker lever
- 711 Bolt handle catch
- 712 Bolt catch
- 713 Spring for bolt catch
- 714 Unlock slide
- 715 2 straight pins
- 716 Pressure spring
- 717 Spring bolt
- 718 Trigger lever
- 719 Safety lock
- 720 Spring bolt
- 721 Pressure spring
- 722 Adjustment screw
- 723 Rocker lever
- 724 Spring bolt
- 725 Spring
- 726 Safety lever
- 727 Spring counter bearing
- 728 Trigger housing
- 729 Adjustment screw
- 730 Roll

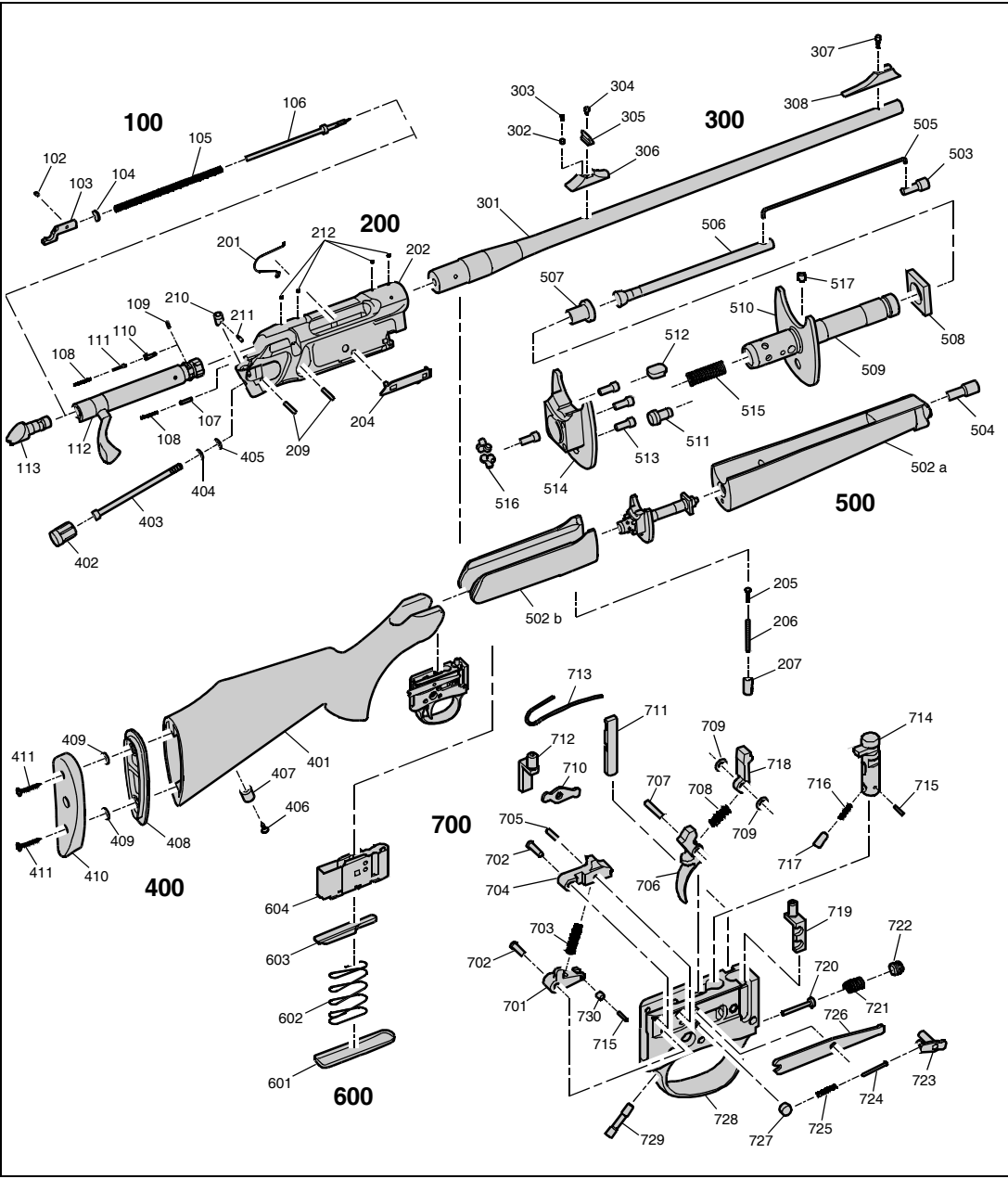


Fig. 26, Spare parts for Sauer 202 Take Down

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